

Date: Tuesday, May 22, 2007 6:47:37 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPLATE		
Job Number	25034					
Estimate Number	10606					
P.O. Number	N/A		Part Number	D33193		
This Issue	11/29/2005 S.O. No. : N/A		Drawing Number	D3319 REV. B		
Prsh Rev.	NC		Project Number	N/A		
First Issue	N/A		Drawing Revision	B		
Previous Run	N/A		Material	N/A		
Written By	<u>See COMMENT BELOW</u>		Due Date	12/21/2005	Qty:	10 Um: Each
Checked & Approved By	<u>EST REV A 05-05-12 KSL/SM</u>					
Comment	Created By Auto Work Order					

Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		

Comment: PURCHASING
 Issue P/O: 00000186 AS5/11/30
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3319
 Possible Supplier: Industrial Laser
 Material release note is required

Tools:

2.0	D33193F	Wearplate		
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
WEARPLATE

Tools:

3.0	PACKAGING 1	PACKAGING RESOURCE #1		
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Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

DL 05/12/30 10

Tools:

4.0	QC6	DIMENSIONAL CHECK		
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Comment: DIMENSIONAL CHECK
 Inspect dimensions as per inspection template D3319-3T1

Jas:01-05 10

Tools:

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

N/P

Tools:

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 06/01/02

10

Tools:

7.0 QC6

DIMENSIONAL CHECK



JOG-01-09

10

Comment: DIMENSIONAL CHECK

Tools:

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	M19682

CPC 06.02.27

Tools:

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11.06/03/01

10

Tools:

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Q.C. 06 ~ 03 ~ 09

Tools:

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06 03 09

Tools:

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng.	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 361

Tools:

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Tools:

Job Completion



Re 9/3/21

DOB 10/3/14

U 06c0314

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 82121, Auckland, New Zealand
Telephone: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 233 3535 Waikato
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5005/21329

CUSTOMER	Wilkinson	P41007DI002	SPECIFICATION	ASTMA1088 CS Type A	CERTIFICATE No	TC107797																		
CUSTOMER O/N	90-21N-288		PRODUCT	CRA WIDE COIL																				
MILL O/N	453666		DIMENSIONS	0.044" x 48" x Coil	PAGE	1 of 1																		
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																						
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N ₂	CE()	MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)						
		x100						x1000						x10000		x100	180°	BEND	YIELD	T.S.	%ELONG G.L=	HARDNESS HRB	r	LENGTH (feet)
R9-455948-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					Good				49		1729
R9-455949-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					Good				49		1296
R9-455951-00	638405	5	1	20	13	19	12	19	17	1	5	1	1					Good				49		2064
R9-456216-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1					Good				54		1926
R9-456217-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1					Good				54		1978
R9-456218-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1					Good				52		1926
R9-456219-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1					Good				52		1978

J 06-01-05

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=0 (B)=90	IMPACT TEST (C)=45 (D)=(r+90+2r45)/4	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15	(C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Patish Misra*
QC METALLURGIST

18 ga CRMS

100#186

